

# Del 1.25 Work Order ID 73646

Thursday, September 08, 2011 2:48:07 PM

Page 1

Item ID: D4000-9

Accept

Setup Start

Revision ID:

Stop

Item Name: Grommet

Start Date: 9/9/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: *mk* Date: *11-09-08* Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4000	A

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER DWG AND FOLIO FA910

DWG REV: *1/14*

FOLIO REV: *1/14*

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*14* *φ*

*14* *φ*

*14* *φ*

*11/9/22*

*11/18/22*

*11/01/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73646**

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Page 2

Item ID: D4000-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Grommet

Start Date: 9/9/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: *11A*

0.00



Packaging

Memo

0.00

Packaging

*11-09-23**14**0*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/9/27**11-09-23*  
*(14)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

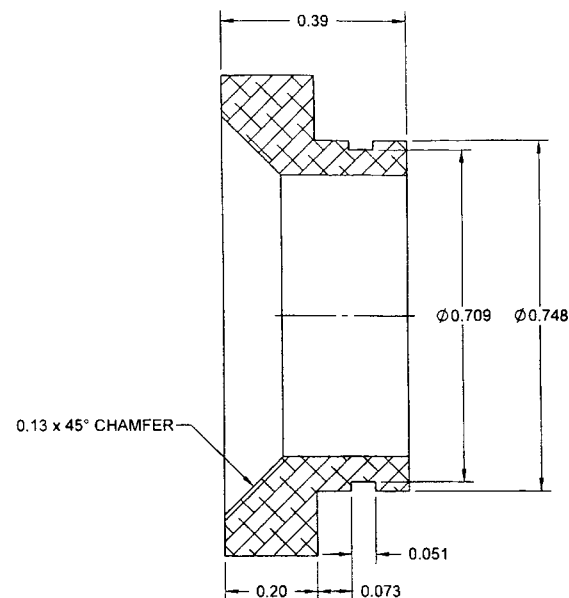
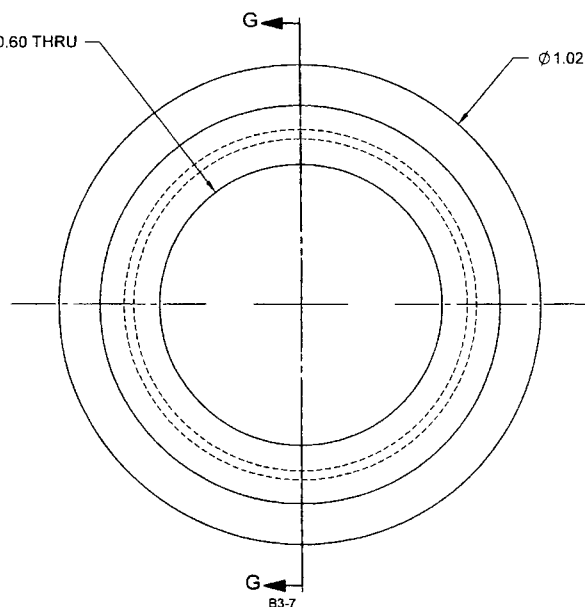
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-9	JCA-M47-1-11

DRILL Ø0.60 THRU



**SECTION G-G**

B6-7

**D4000-9 GROMMET**

**RELEASED**  
2010-05-05

- NOTES:
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø 1.000 ROUND BAR  
REF DART SPEC M-DELRIN-R1.000
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.01 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. A
CHECKED	<i>[Signature]</i>	<b>D4000</b>	SHEET 7 OF 8
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	<b>FITTING</b>	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.02.10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 08, 2011 2:48:03 PM

Page 1

Work Order ID: 73646



Parent Item: D4000-9



Parent Item Name: Grommet


Start Date: 9/9/2011

Required Date: 9/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-02-05 JLM VERIFIED BY:EC IPP rev B  
10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.2500  DELRIN ROUND BAR 1.25"		Purchased	No			100	f	12.8020	0.05	0.631579		10/9/22	

Location

MAT055

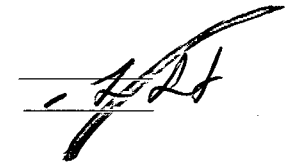
Loc Qty

12.802

Loc Code

12.802

114586



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

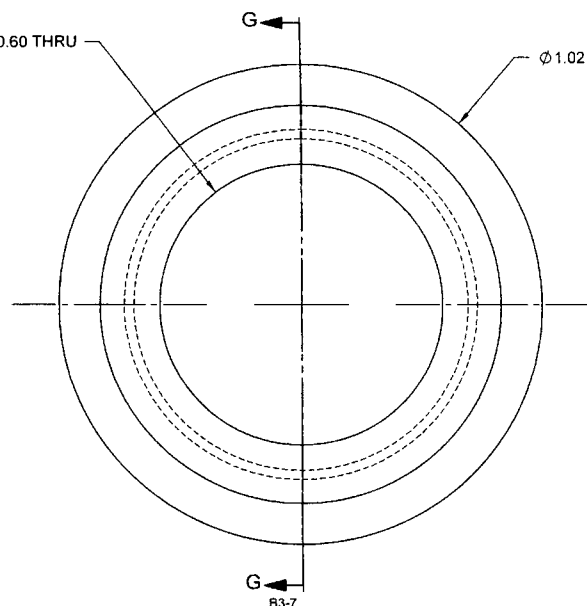
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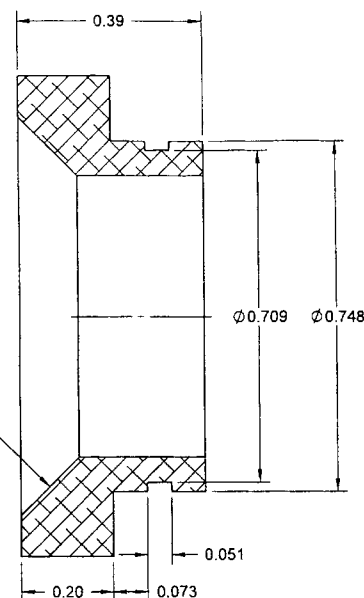


DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-9	JCA-M47-1-11

DRILL Ø0.60 THRU



0.13 x 45° CHAMFER



**SECTION G-G**  
B6-7

**D4000-9 GROMMET**

# 73646

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DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4000</b>	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>FITTING</b>	NTS
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**RELEASED**  
2010-05-05  
MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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